

6061.0750

Work Order ID 127965

December-18-14 11:51:11 AM

127965

Page 1

Item ID: D5101-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Insert

Stop ***NS2***

Start Date: 12/18/14 Start Qty: 160.00

160

Cust Item ID:

Required Date: 1/05/15 Req'd Qty: 160.00

160

Customer:

Reference:

Approvals:

Process Plan: U

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5101									

100

0.00

100

Hardinge CNC LATHE SMALL

Doosan

Memo

0.00

Doosan Lathe

TURN AS PER FOLIO FB 358

FOLIO REV: N/ADWG REV: A

DEBURR

160 _____ SL15-1-4

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

160 _____ SL15-1-4

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Item ID: D5101-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Insert
 Start Date: 12/18/14 Start Qty: 160.00 ***160*** Cust Item ID:
 Required Date: 1/05/15 Req'd Qty: 160.00 ***160*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						160			38
QC	Memo	0.00							15-01-08
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130						160			15-1-14
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150						160			DAS
QC	Memo	0.00							38
Quality Control									9-89

JAN 15 2015

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Item ID: D5101-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Insert
 Start Date: 12/18/14 Start Qty: 160.00 ***160*** Cust Item ID:
 Required Date: 1/05/15 Req'd Qty: 160.00 ***160*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <i>St 149</i>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

160 JAN 19 2015

15/1/19

MF 15-1-19

Picklist Print

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Work Order ID: 127965

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Parent Item: D5101-5

D5101-5

Parent Item Name: Insert

Start Date: 12/18/14

Required Date: 1/05/15

Start Qty: 160.00

Required Qty: 160.00

Comments: IPP REV:A NEW ISSUE 14-12-18 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased		No			f	72.0000		8			

M6061T6R0 750

6061-T6 Round Bar .750"

22 15-1-4

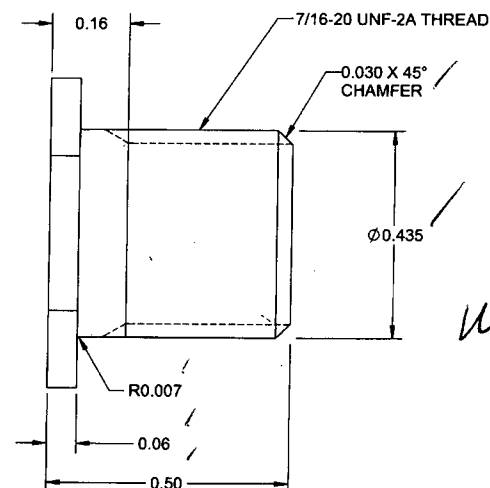
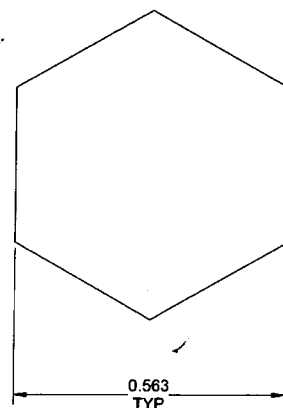
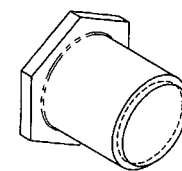
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT012	72	
m130745	72	

6.33

* 3.06 x 50 pcs

130527

↑
not in system



W/0127965

D5101-5 INSERT

RELEASED

2014 NOV 24

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.008 lbs

APPROVED

DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5101	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CROSSBOLT SPACER	NTS
DATE	14.08.07	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

127965

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: SL	Audited by: 	Preliminary Approval:
Date: 15-1-14	Date: 15.01.08	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	